Work Order ID 120367

Wednesday, June 04, 2014 3:03:10 PM

120367

Page 1

Treamesauy, Jun	C 04, 2014 5.05.10 1 M										
Item ID: Revision ID: Item Name:	D3535-35 Stainless Steel Wearplate Aft		Accept	*N900	040	10	N *	Setup	Start Stop		S1*
Start Date: Required Date: Reference:	6/04/14 Start Qty: 12.00	1 /	ţ	Cust Item I Customer:	ID:				Stop	*N:	S2*
Approvals:	Process Plan: MLJ	Date: 14-06-06	Tooling:	D:	ate:	_		Run	Start	*NI	R1*
	QC:	Date:	SPC (Y/N):	Da	ate:		-		Stop	*NI	R 2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	****									<u> </u>
D3535	Rev B										
100 *100* Waterjet	FLOW WATER JET Memo		0.00				(12)			ma	14/06/1
FLOW CNC Waterjo		er Dwg D3535 Dwg Rev:_ eccessary	_	2-		**					
110	QC2- Inspect parts off	machine FAI/FAIB	0.00								
110 QC Quality Control	Memo		0.00				(12)		<u> </u>	mm	14/26/(1
				AS 27							
*120	QC8- Inspect parts - sec	cond check	0.00 PB 9	-89			(iŹ))	*,		
QC Quality Control	Memo		0.00				count	-			

DQA:		Date:											
					WORK ORDER NON	-CO	ONFO	RMANCE / U	PDATE				AEROSPACE
QA Closed:		Date:								ork Order up	odate only		
Work Order	:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part No NCR No				1	Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	X	Engineering Quality Other
	1	1	1					1		l a	<i>i</i>		
Root Cause	Dat	e Step	Qty	Desc	ription of work order update or non-conformance		nitial iief Eng	Act Descr	rion ription	Sign & Date	Verification	,	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved				Had wat hard	trouble with the erjet, Sand had a lime keeping up.		<u> </u>		change the				
1	<u> </u>			<u>. </u>	· · · · · · · · · · · · · · · · · · ·	FAI	ULT CA	TEGORY		<u>l</u> :			
Landing	Gear				General						· · · · · · · · · · · · · · · · · · ·		
	Bendi Centro Cracks Crimp Cuffs Crush Heat	e Not Conce Kink/Ripple	e/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misrea Off-set	ion Incomplete/Ur tions Incomplete/U gned/off center eled d	· —	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Movéd Positioned V Power Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	-	/Twist in Tul			Fit/Function	一	•	Sequence					

Work Ord Wednesday, Jun					*120	1367*						Page 2	
Item ID: Revision ID: Item Name:	D3535-35 Stainless Steel	Wearplate Aft			Accept	*N900	040	100	ን* ፡	Setup Sta	IV	IS1* IS2*	=
Start Date: Required Date: Reference:	6/04/14 : 6/04/14	Start Qty: 12.00 Req'd Qty: 12.00		12* 12*		Cust Item 1 Customer:	ID:				1.0		
Approvals:	Process Pla	n;	Date:	•	Tooling: SPC (Y/N):		ate:		- 4e € F	Run Sta Sto	^I\\ ^p	R1*	
Sequence ID/ Work Center II 130 *120* Brake NC	D	Operation Description NC BRAKE Memo			Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 36 9-89
140 *1 4 0* OC		1-Deburr if n	DT8326.3-Ider	itify as D353	as per Dwg D3535 usin 35-35.	g Jigs AS 27 89			[CI			/ /	

:150

150 Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSIQ05 4.3

0.00

Memo 0.00

START TIME: OMEN TEMPERATURE:

FINISH TIME:

D & 14-6-19 853

DQA:			_ Date:			•			_					
04.61			Data			WORK ORDER NON	-C(ONFO	RMANCE / UPDAT					AEROSPACE
QA Closed:			Date:					<u> </u>		VV	ork Order up	date only		
Work Ord	er:					DISPOSITION			AG	GAINST DE	PARTMENT	/PROCESS		
	•					Rework]	1	Skid-tube Cros	sstube]	Water Jet	\neg	Engineering
Part I	۱o.					Scrap	1		—	all Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is	1	Therr	noforming Fir	nishing	Rec/Sto	re/Packaging		Other
NCR I	۷o.					Suspected Unapproved			Large Fab Com	nposite]	Supplier		
		***************************************	 1		5	2.4		,	1 4 11		l c: o		-	
Root		Data	Chair	Q4	Desci	ription of work order update		Initial	Action		Sign &	Manifi andi an		061
Cause		Date	Step	Qty		or non-conformance	Cn	nief Eng	Description		Date	Verification	1	QC Inspector
Design Doc/Data														
Equip/Tooling													İ	
Handling/Pre														
Material													Ì	
Operator														
Offset/Setup														
Process											:		ı	
Supplier														
Training							1					:		
Transport														
Unapproved							<u> </u>							
							FA	ULT CA	TEGORY					
Landi	ng (1			_	General		1		_	1	Г	_	
		Bending			-	Bend	<u> </u>	1	Program	<u> </u>	Outside Dim		\neg	Pressure/Forced
		Centre No	ot Concen	ntric	-	BOM/Route		Grain		<u> </u>	Over/Under	- I	_	Set-up
	H	Cracks	-1-/D:I-	/\ \ / = =	-	Broken/Damage/Defect	\vdash	Hardwa			Part Incorred		_	Temperature/Cure
	\vdash	Crimp/Kii Cuffs	пк/кірріе,	/ wave	-	Burrs Contamination	-	1 '	ion Incomplete/Unqualific		Part Lost/Mi Part Moved	ssing	\dashv	Weld Wrong Stock Pulled
		Crushing				Countersink		4	cions Incomplete/Unclear gned/off center	<u> </u>	Positioned V	/rong		Wrong Stock Fulled
	-	Heat Trea				Cut Too Short	\vdash	Mislabe		-	Power Loss/			Other
	-	Inspectio		Tube	-	Drawing		Misrea		<u> </u>	1. 04461 2033/	Z. 20 [
	-	Marks/Ch	•			Drill Holes	-	Off-set	•					
		Turning S				Finish	F	1	Calibration					
		Wave/Tw				Fit/Function		4	Sequence					

Work Ore Wednesday, Ju				*120	1367*						Page
Item ID: Revision ID:	D3535-35			Accept	*N900	040	100	*	Setup Sta	rt *N	S1*
Item Name:	Stainless St	eel Wearplate Aft							Sto	^p *∖	S2*
Start Date:	6/04/14	Start Qty: 12.00	*12*		Cust Item	m.					. 17
Required Dat	e: 6/04/14	Req'd Qty: 12.00	*12*		Customer:						
Reference:											
Approvals:	Process P	Plan:	Date:	Tooling:	D	ate:			Run Sta	^! <i>\</i>	R1*
	QC:		Date:	_ SPC (Y/N):	D	ate:			Sto	*N	R2*
Sequence ID/ Work Center	ID	Operation Description	100	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		QC3- Inspect Part Finish		0.00				x -3	~~)	. willoci	Damp

Work Center ID	Description		Run Hour	·s	10011D	1001#	Code	Qty	Reject Qty	Keject Number	Insp. Stamp
160	QC3- Inspect Part Finish	(0.00					1	- •		•
160								12			
QC	Memo	(0.00	DAS							
Quality Control				27							
		5 2 - 2		14/0/1	9						

Identify as per dwg & Stock Location: FP-ON 170 *170*

0.00

Packaging Memo Packaging

180 QC21- Final Inspection - Work Order Release

Memo

Quality Control

120

0.00

0.00

Page 3

DQA:			Date:			•								
						WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE				_	AEROSPACE
QA Closed:			Date:						 	W	ork Order u	odate only		········
Work Ord	er:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
						Rework			Skid-tube Crosstube		1	Water Jet		Engineering
Part I	No.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.		Quality
						Use-as-is		Therr	noforming Finishing		1	re/Packaging		Other
NCR I	No.					Suspected Unapproved			Large Fab Composite	\subseteq		Supplier		
		•	, 	7					·					
Root		_	_		Desc	ription of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	١	QC Inspector
Design		•												
Doc/Data														•
Equip/Tooling														
Handling/Pre Material														
Operator														•
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved			·											
							FAI	ULT CA	TEGORY					
Landi	ng G					General		1 .			1	-		
		Bending	_		<u> </u>	Bend		1	Program	\vdash	Outside Dim	⊢	-	Pressure/Forced
		Centre No	ot Concer	ntric	·	BOM/Route		Grain		<u> </u>	Over/Under	F	_	Set-up
		Cracks	-1./D:1-	/\A1==		Broken/Damage/Defect		Hardwa		\vdash	Part Incorre	-	_	Temperature/Cure
		Crimp/Kir	nk/kippie,	/wave	-	Burrs		1	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	ssing	-	Weld
		Cuffs Crushing			_	Contamination Countersink		1	tions Incomplete/Unclear gned/off center	-	Part Moved Positioned V	L Vrong		Wrong Stock Pulled
		Heat Trea			\vdash	Cut Too Short	-	Mislabe		\vdash	Positioned v	- · -	\neg	Other
	-	Inspection		Tube	-	Drawing	-	Misread		<u></u>	J. 0WC1 1033/	Juige [_	Other
	-	Marks/Ch	-			Drill Holes	\vdash	Off-set						
		Turning S				Finish	\vdash	4	Calibration					· · · · · · · · · · · · · · · · · · ·
		Wave/Tw	•			Fit/Function		ł	Sequence					

Picklist Print

Wednesday, June 04, 2014 3:03:09 PM

Work Order ID: 120367

120367

Parent Item:

D3535-35

Parent Item Name: Stainless Steel Wearplate Aft

D3535-35

Start Date: 6/04/14

Required Date: 6/04/14

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM

Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304\$20GA		Purchased	No	***	-	100	sf	279.1519	0.8022	10.13305			
M304S20 304/316 .040 Sheet	NGA								** _			mm	19/06/
				Location		Loc (<u>Oty</u>	Loc Code					
				MAT020		279.1518	3948						
				· n	n126852	(0.31		_				
				n	n127454	26 1018	2048						

126.74

126

m128435

m129128

DQA:		Date:		· · · · · · · · · · · · · · · · · · ·								TOART	
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPDATE	W	ork Order u	odate only	AEROSPACE	Ē
W. J. O. J.					DISPOSITION			AGAINS [*]		PARTMENT	·		
Work Orde	r:					,		a		1	ъ	¬	
D+ N	_				Rework			Skid-tube Crosstube	\vdash		Water Jet	Engineering	,
Part N	0				Scrap			Machining Small Fall noforming Finishing	-	4	d. Eng. Coor.	Quality	
NCR N	0				Use-as-is Suspected Unapproved		merr	noforming Finishing Large Fab Composite	_	, Kec/Sto	re/Packaging Supplier	Other	
WCK IV	·				Suspected Ollappioved	ı		Large rab Composite	- <u> </u>	J	20philei [<u>. </u>	
Root				Desci	ription of work order update		Initial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector	
Design								·					
Doc/Data					·						1		
quip/Tooling								`					
landling/Pre													
Material		1			,						ļ		
Operator													
Offset/Setup								,					- 1
Process												V	
upplier								,					
raining													
ransport	_							·					
Inapproved			<u> </u>			<u> </u>							
					· · · · · · · · · · · · · · · · · · ·	FAI	ULT CAT	regory		······			
Landin				_	General		1 .		_	1	г		
1	Bending			<u> </u>	Bend		1	Program	\perp	Outside Dim	⊢	Pressure/Forced	
	Centre No	ot Concer	ntric	_	BOM/Route	<u> </u>	Grain	·	\vdash	Over/Under	-	Set-up	
	Cracks				Broken/Damage/Defect	_	Hardwa		-	Part Incorred	 -	Temperature/Cure	
Ĺ	Crimp/Kir	nk/Ripple	e/Wave	_	Burrs	<u> </u>	1	ion Incomplete/Unqualified	-	Part Lost/Mi	ssing	Weld	
-	Cuffs			<u> </u>	Contamination	_	4	ions Incomplete/Unclear	\vdash	Part Moved	L	Wrong Stock Pulled	
-	Crushing			<u> </u>	Countersink	\vdash	•	ned/off center	\vdash	Positioned V			
-	Heat Trea		T l.	\vdash	Cut Too Short	<u> </u>	Mislabe		L	Power Loss/	Surge [Other	
-	Inspection	•	ıupe	<u> </u>	Drawing		Misread						_
-	Marks/Ch			-	Drill Holes	\vdash	Off-set						
}	Turning S			-	Finish	\vdash	4	Calibration					
	Wave/Twist in Tube			Fit/Function	1	Jout of S	Sequence						

DART AEROSPACE LTD	Work	Order: 120367
Description: Wearshoe	Part I	Number: D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1

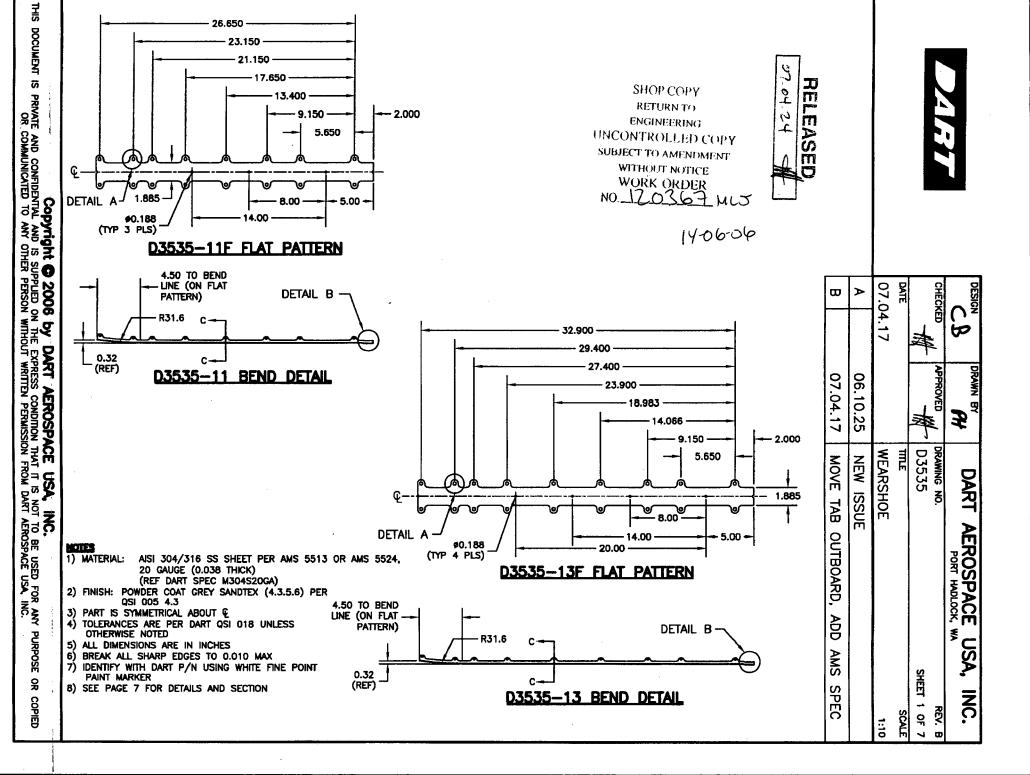
FIRST ARTICLE INSPECTION CHECKLIST

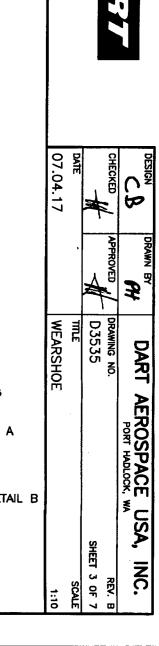
X First Article Prototype

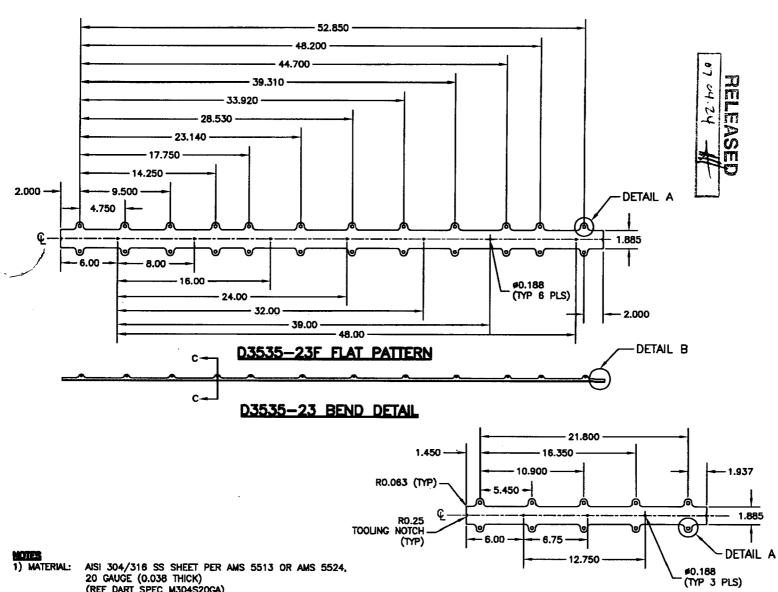
						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2000			V-Jema	
1.885	+/-0.010	1885			7- 5km-06	
6.00	+/-0.030	6.00			2011 00	
6.75	+/-0.030	6.75				
Ø0.188	+0.005/-0.001	0.189				
23.250	+/-0.010	23.250				
19.750	+/-0.010	19.750				
17.750	+/-0.010	17.750				
14.250	+/-0.010	14.250				
9.500	+/-0.010	9.5				
4.750	+/-0.010	4.750				
0.300	+/-0.010	0.363				
0.300	+/-0.010	0.302				
0.038	+/-0.010	0.038				
	-,					
	400			,		

			DAS		
Measured by:	mm	Audited by:	EB 27	Prototype Approval:	N/A
Date:	14/06/11	Date:	14/6/12	Date:	N/A
	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1				

Rev	Date	Change	Revised by	Approved
Α	07.05.10	New Issue	KJ/JLM O	E







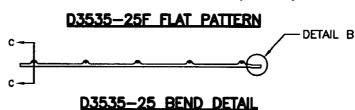
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

BREAK ALL SHARP EDGES TO 0.010 MAX 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT

PAINT MARKER 8) SEE PAGE 7 FOR DETAILS AND SECTION



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CHECKED

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DART

AEROSPACE PORT HADLOCK.

USA,

NC.

DRAWING NO.

SHEET

4 of 7

SCALE 1:10

07.04.17

WEARSHOE

42.40.La REASE SE

19.000 14.250 9.500 6.000 2.000 1.885 6.00 DETAIL A **≠**0.188 (TYP 3 PLS)

- 22.500 -

D3535-31F FLAT PATTERN

D3535-31 BEND DETAIL

	24.50 21.000 - 15.250	00		
2.000				•
1.885	.00 - 6.75 - 13.50 - 13.55 FL/	AT PATTER	#0.188 (TYP 3 PLS)	A

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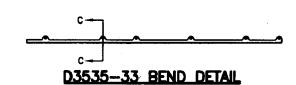
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OR COPIED

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

ALL DIMENSIONS ARE IN INCHES
BREAK ALL SHARP EDGES TO 0.010 MAX
IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION



CHECKED

D3535 DRAWING NO. b

DART

DATE

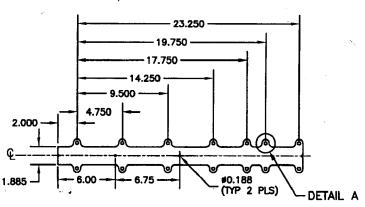
07.04.17

WEARSHOE

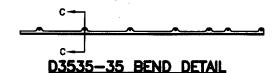
h2 ho 60

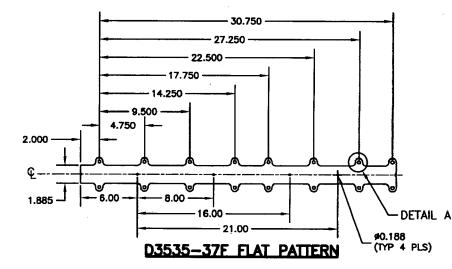
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D3535-35F FLAT PATTERN





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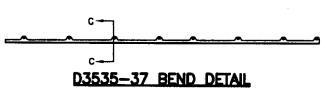
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PURPOSE

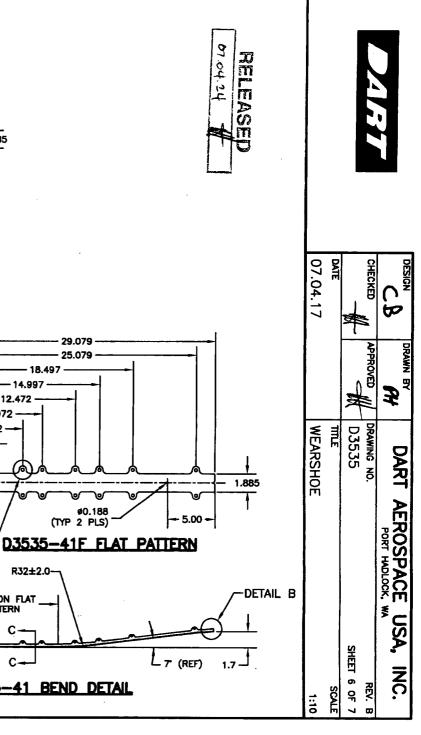
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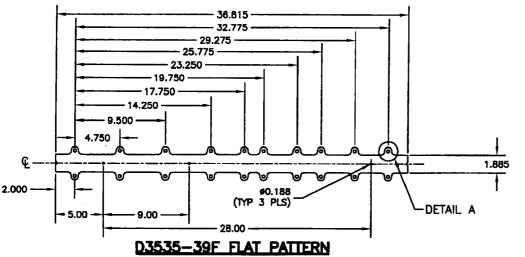
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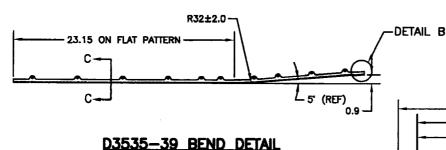
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
- (REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT &
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



 PORT HADLOCK, WA REV. B SHEET 5 OF 7 SCALE 1:10
AEROSTACE USA. INC.

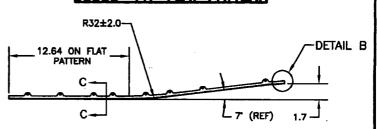






1) MATERIAL: AISI 304/318 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX IDENTIFY WITH DART P/N USING WHITE FINE POINT
- PAINT MARKER 8) SEE PAGE 7 FOR DETAILS AND SECTION



29.079

25.079

#0.188 (TYP 2 PLS)

6.932

DETAIL A

3.432

2.000

D3535-41 BEND DETAIL

PURPOSE

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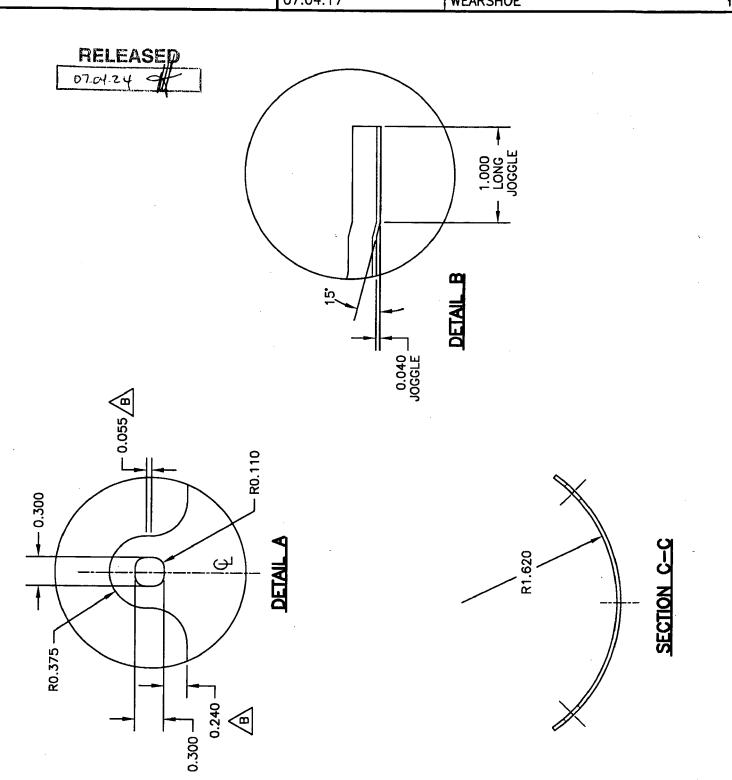
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DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
CHECKED	APPROVED //	DRAWING NO.	REV. B
		D3535	SHEET 7 OF 7
DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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